

Split
Work Order ID 69943 -2

Tuesday, May 24, 2011 2:50:09 PM



Page 1

Item ID: D3564-9

Revision ID:

Item Name: Wearshoe

Start Date: 5/24/2011 Start Qty: 12.00

Required Date: 6/3/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 11-05-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100



Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** | Dwg Rev: D | Prog
Rev: D 2-Deburr if necessary

B11-5-21

(B)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-5-21

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8 1106101

(H3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69943

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Page 2

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

13

Brake NC

Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155. Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SB 11/06/08

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/08

Ensure joggle as per dwg D3429

(43)

150



Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
m11896 Weld hardcoat as per Dwg D3564

2059B Hardcoat

7 11-07-18 JBY
Cpl 11-07-18

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Work Order ID 69943

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Page 3

Item ID: D3564-9

Accept



Revision ID:

Setup Start



Item Name: Wearshoe

Stop



Start Date: 5/24/2011 Start Qty: 12.00



Required Date: 6/3/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

5 ulot 19

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

5 ulot 19

(+7)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 117338

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:30

2:00

2:30

7 BR 11-7-19

Powdercoat

Powder Coating

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Page 4

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Required Date: 6/3/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



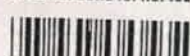
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Pump/20 ⑦

200

Identify as per dwg & Stock Location: *FP*

0.00



Packaging

Memo

0.00

Packaging

Po 4/20 ⑦

2.0

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/2011
MF
11-07-20*

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 2:50:06 PM

Page 1

Work Order ID: 69943

Parent Item: D3564-9

Parent Item Name: Wearshoe



Start Date: 5/24/2011

Required Date: 6/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA



304/316 Sheet .063

Purchased

No

100

sf

167.8000

1.41

17.81053



1311-5-31

Location

MAT020

117275

117653

Loc Qty

167.8

7.8

160

Loc Code

117653

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69943
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225	X		V B&Z	
2.432	+/-0.010	2.438	X		V	
2.50	+/-0.030	2.52	X		V	
6.000	+/-0.010	6.000			T B&I	
12.104	+/-0.010	12.104	S		T	
18.000	+/-0.010	18.00	9		T	
18.000	+/-0.010	18.00	L		T	
18.00	+/-0.030	18.00	X		T	
9.00	+/-0.030	9.00	X		T	
11.50	+/-0.030	11.50	X		T	
0.300 x 0.300	+/-0.010	301 x 302	X		V	
Ø0.188	+0.005/-0.001	0.190	X		V	
R0.375	+/-0.010	0.375	X		V	
0.063	+/-0.010	0.058	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A	
Date: 11-5-31	Date: 11/6/61	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

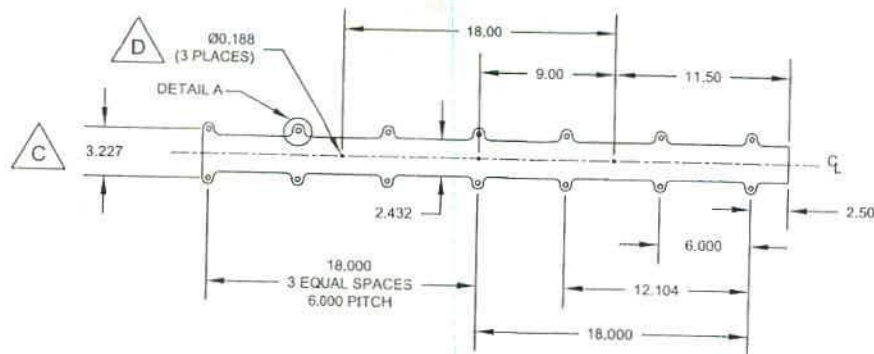
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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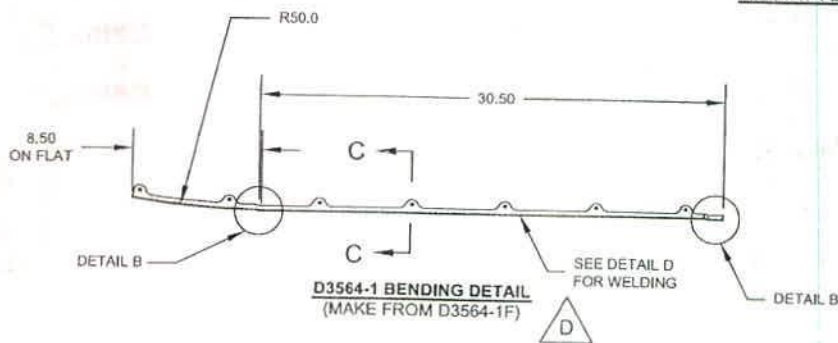
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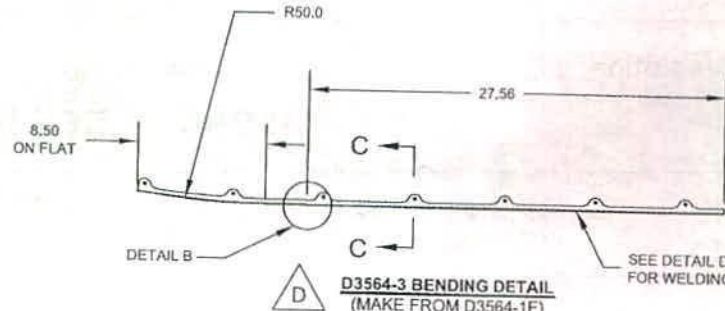
D3564-1F FLAT PATTERN

RELEASED

07.09.04



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

CL 11/05/24
W10: 69943

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.28 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 B6,B9: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
TITLE WEARSHOE
REV. D
SHEET 1 OF 3
SCALE 1:8

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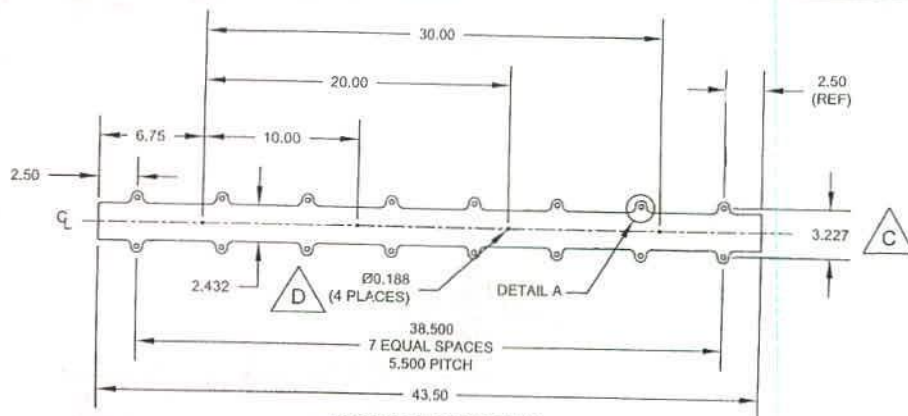
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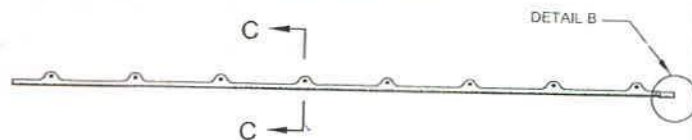
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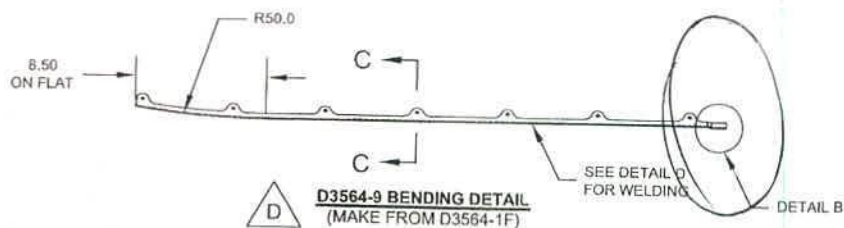
NOTE: Date & initial all entries



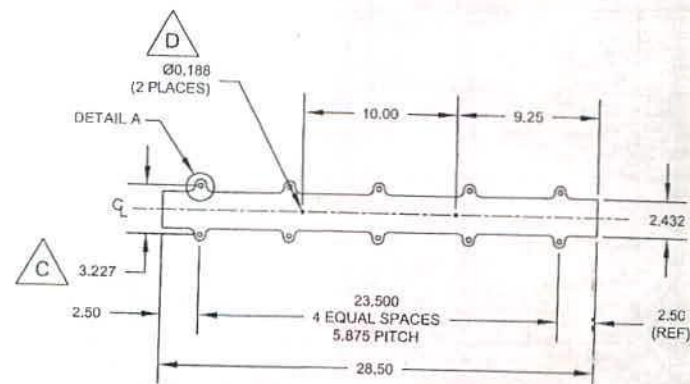
D3564-5F FLAT PATTERN



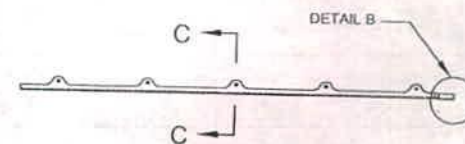
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



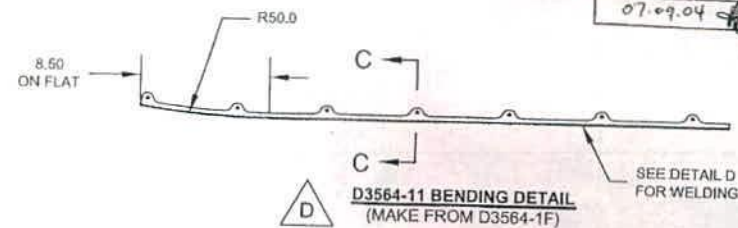
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

#69943

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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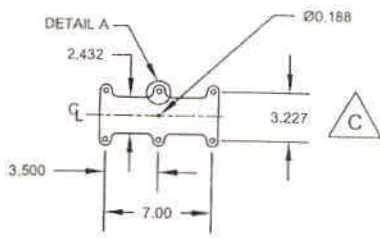
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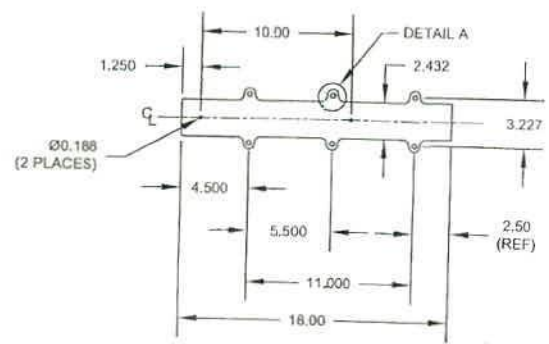
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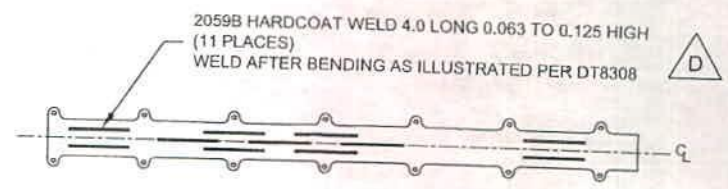
NOTE: Date & initial all entries



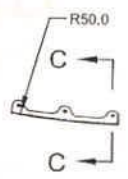
D3564-13F FLAT PATTERN



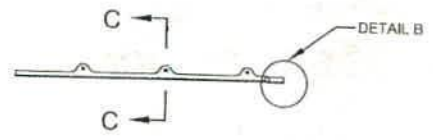
D3564-15F FLAT PATTERN



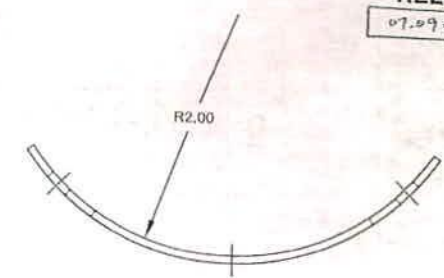
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

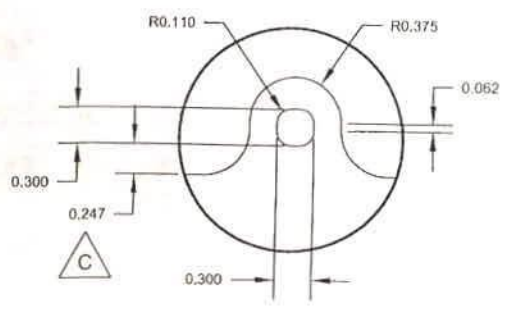


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

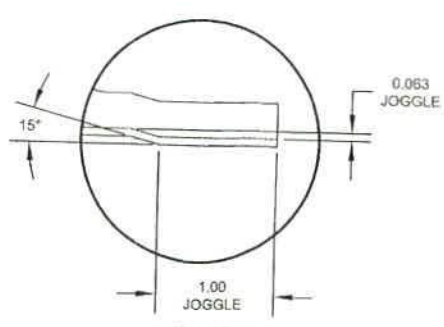


SECTION C-C
SCALE 1:1

RELEASED
07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

64943

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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